

Date: Wednesday, 4/19/2006 7:35:21 AM
 User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: BATTERY LOCK ASSEMBLY
Job Number	: 26701		
Estimate Number	: 10900		
P.O. Number	: N/A	Part Number	: D3393041
This Issue	: 4/19/2006 S.O. No. : N/A	Drawing Number	: D3393 REV A
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: N/A Type : MACHINED PARTS	Drawing Revision	: A
Previous Run	: N/A	Material	: N/A
Written By	: <u>See comment below</u>	Due Date	: 4/25/2006 Qty: 8 Um: Each
Checked & Approved By	: <u>06.04.19</u>		
Comment	: Est Rev: A New Issue 05-11-22 JLM		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	D27287	Decal
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 8.0000 Each(s)

Pick:

Qty Part Number	Description	Batch
1 D2728-7	Decal	<u>B22594</u>

2.0	D33731	Cam Lock
-----	--------	----------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 8.0000 Each(s)

Pick:

Qty Part Number	Description	Batch
1 D3373-1	Cam Lock	<u>B23643</u>

3.0	D33695	Inventory
-----	--------	-----------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 8.0000 Each(s)

Pick:

Qty Part Number	Description	Batch
1 D3369-5	Washer	<u>B26212</u>

4.0	516WC	SS Flat Washer 5/16
-----	-------	---------------------



Comment: Qty.: 2.0000 Each(s)/Unit Total : 16.0000 Each(s)

Pick:

Qty Part Number	Description	Batch
2 5/16WC	SS Flat Washer	<u>M19611</u>

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BATTERY LOCK ASSEMBLY

Job Number: 26701

Part Number: D3393041

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

D33931

Battery Lock Casing



Comment: Qty.: 1.0000 Each(s)/Unit Total : 8.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

1 D3393-1

Battery Lock Casing

B23552

6.0

D33933

Cam Lock Shaft



Comment: Qty.: 1.0000 Each(s)/Unit Total : 8.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

1 D3393-3

Cam Lock Shaft

B23536

SAD 06:05:30

7.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1-Open D3373-1 lock package. Keep keys, lock body, lock body nut, flat cam and lock barrel. Discard the rest.

2-Using the flat cam, fabricate D3369-5 as per Dwg D3369 Identify as D3369-5

3-Assemble D3393-041 as per Dwg D3393. Insert lock body and fasten with lock body nut, apply locktite, then insert lock barrel. Insert D3369-5 fabricated washer and 5/16" SS washer. Thread D3393-3 shaft into lock, then install decal.

A/RN/A262 Locktite

16507

4-Identify as D3393-041 and attach keys. Ensure that assembly locks and unlocks smoothly. Record the Key

Key Numbers

1- C420A

5- C420A

2- C420A

6- C420A

3- C420A

7- C420A

4- C420A

8- C420A

SAD 06:04:30

(8)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☒ DQA: ☒ Date: 06/06/15
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
06-05-30	7	1 Piece scrap and (P3373-1)	<i>[Signature]</i>	Scrap and destroy replace.	SAD 06-05-30	<i>[Signature]</i> 06-05-31	<i>[Signature]</i> 06-05-31	<i>[Signature]</i> 06-05-30

NOTE: Date & initial all entries

Date: Wednesday, 4/19/2006 7:35:21 AM
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

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Job Number: 26701

Part Number: D3393041

Job Number:



Seq. #:

Machine Or Operation:

Description :

8.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

Tack Weld lock shaft to flat cam of a Max 1/8" Long

Qty Part Number Description Batch

A/R N/A SS Rod M1005A7

1 Tack 06.06.10

PD 06.06.10

9.0

QC5/9

WELD INSPECTION



Comment: WELD INSPECTION

MA 06/06/10 (8)

10.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 572

AL 06/06/10 (9)

11.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

SP 06/06/10 (8)

Job Completion



U 06.06.10

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

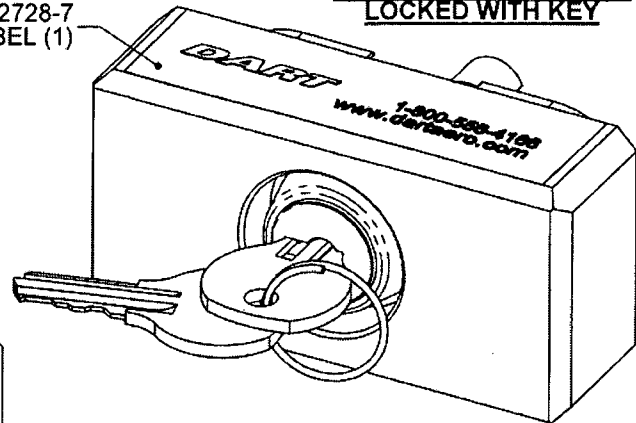
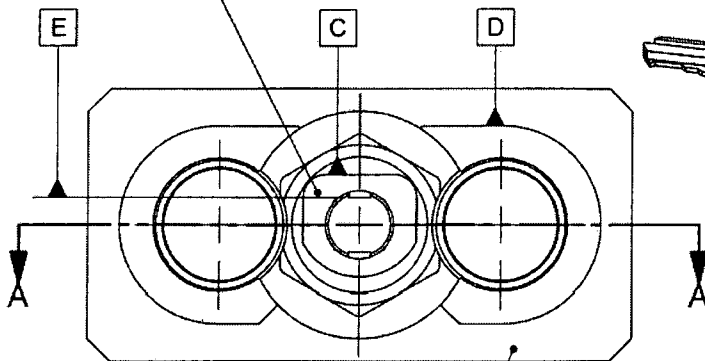
NOTE: Date & initial all entries

DART

DESIGN <i>[Signature]</i>	DRAWN BY <i>[Signature]</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3393	REV. A SHEET 1 OF 3
DATE 05.02.08		TITLE BATTERY LOCK	SCALE 1:1
A	05.02.08	NEW ISSUE	

RELEASED
[Signature]

05/03/09

D2728-7
LABEL (1)**BATTERY LOCK SHOWN
LOCKED WITH KEY**POSITION FACE **C** OF D3369-5
PARALLEL TO FACES **D** AND **E**
AS SHOWND3373-1
CAM LOCK
ASSEMBLY (1)D3393-1
CASING (1)Ø5/16" WC S/S
WASHER (2)

D3369-5 SPACER (1)

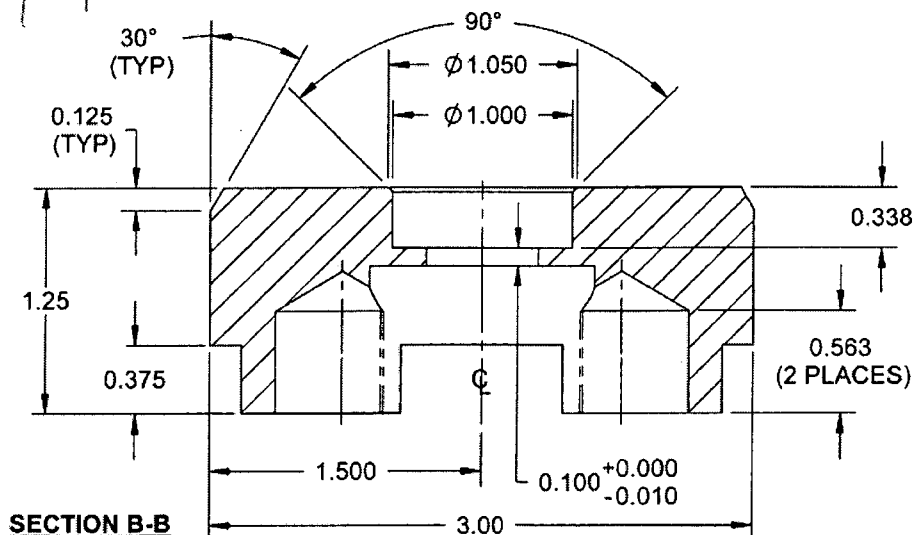
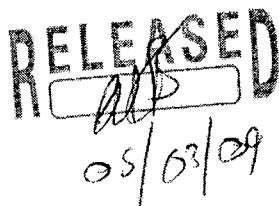
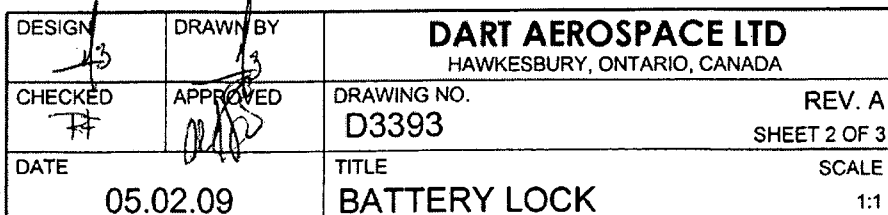
PRESS FIT POLYETHYLENE CAP (2) $\frac{2}{2}$
AND APPLY KRAZY GLUE0.09^{+0.03}
-0.01 (2 PLACES)D3393-3 CAM
LOCK SHAFT (1)TACK WELD
D3393-3 TO D3369-5**SECTION A-A****D3393-041 BATTERY LOCK ASSEMBLY****NOTES:**

- 1) WELD PER DART QSI 004
- 2) POSSIBLE SUPPLIER: McMASTER-CARR, P/N 9567K21

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D3393-1 CASING

1) MATERIAL: 6061-T6/T651 (QQ-A-200/8 OR QQ-A-225/8) S
(REF. DART SPEC. M6061T6B)
2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT FIRE RED (4.3.5.10) PER DART QSI 005 4.3
3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
4) ALL DIMENSIONS ARE IN INCHES
5) BREAK ALL SHARP EDGES 0.005 TO 0.010

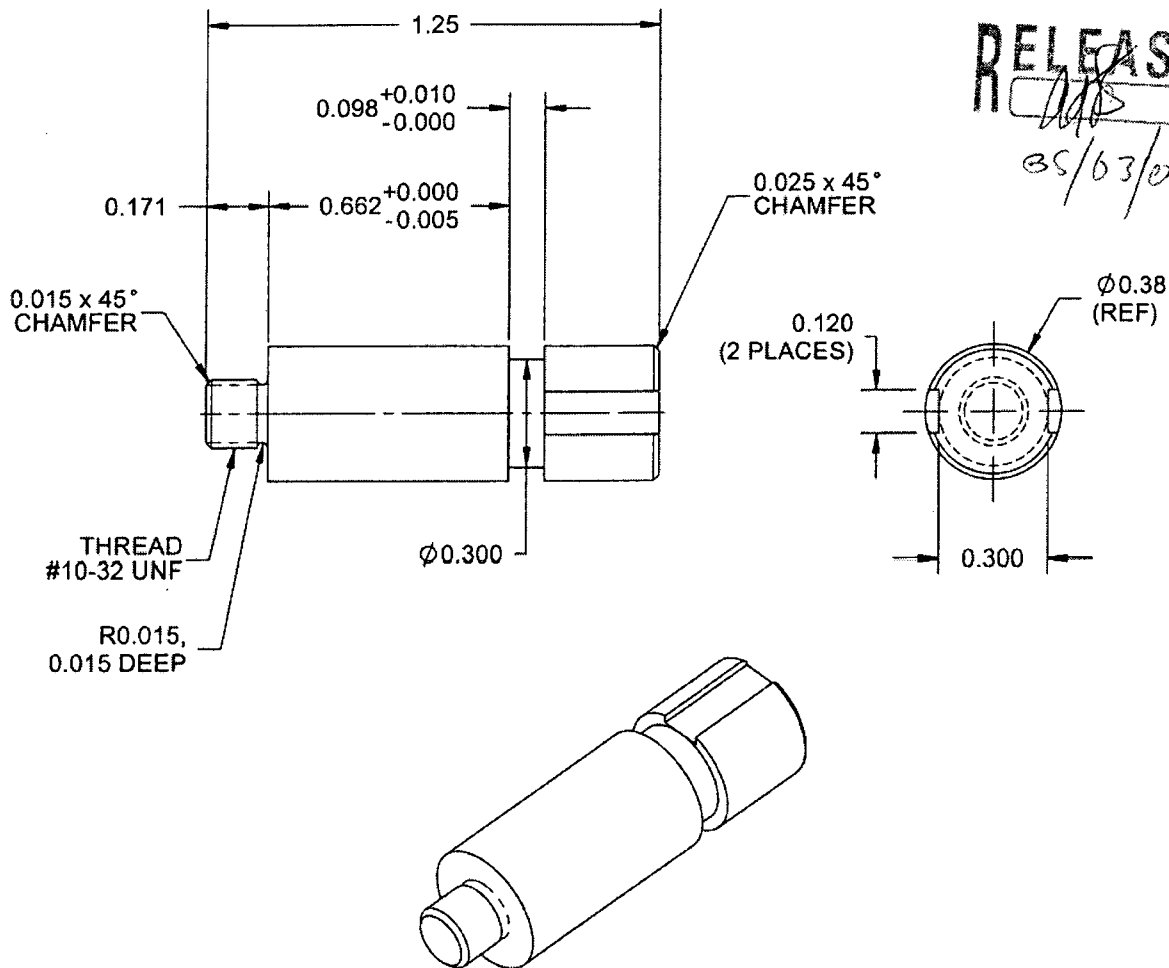
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CHECKED <i>TF</i>	APPROVED <i>LB</i>	DRAWING NO. D3393	REV. A SHEET 3 OF 3
DATE 05.02.09	TITLE BATTERY LOCK		SCALE 2:1

**D3393-3 CAM LOCK SHAFT****NOTES:**

- 1) MATERIAL: AISI 303 S.S. (REF. DART SPEC. M303R0.375)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

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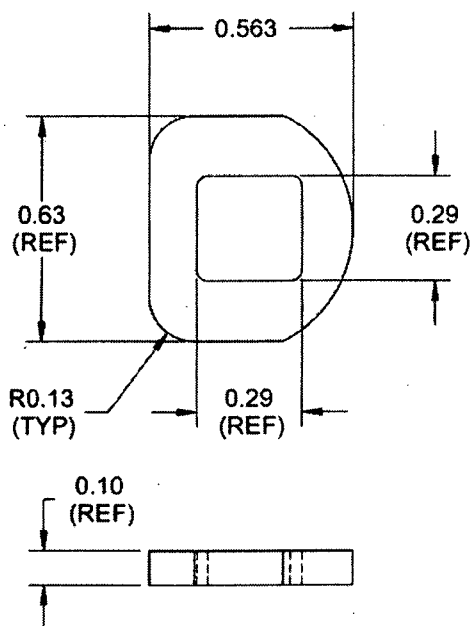
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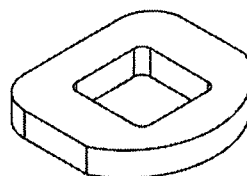
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CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3369	REV. A SHEET 4 OF 4
DATE 04.12.16		TITLE BATTERY LOCK	SCALE 2:1

SPECIFICATION CONTROL DRAWING



RELEASED
[Signature]

05/02/11



-5
D3369 SPACER

NOTES:

- 1) MATERIAL: SUPPLIER BY D3373, MODIFIED AS SHOWN
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

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